Date:

Monday, 10/16/2006 2:01:26 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 29007

Estimate Number

: 10725

P.O. Number

First Issue

HIM:

This Issue Prsht Rev.

: 10/16/2006

: NG

: MA : 28933

S.O. No. : NA

Type

: MACHINED PARTS

Previous Run Written By

Checked & Approved By

Comment

Now machined in house.

NG

: D2652 **Part Number**

: D2652 REV A

: BUSHING

Drawing Number Project Number

Drawing Name

: N/A

Drawing Revision

Material **Due Date** AI 4: : 11/15/2006

Qty:

200 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

303 Round Bar 0.500"

M303R0500

Comment: Qty.: 0.0578 f(s)/Unit Total: 11.5500 f(s)

Material:303 ss .500" Round Bar

(M303R0500)

Batch: 102 447

2.0

1.0

HARDINGE CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

JF 06/11/03

2-Deburr

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

PACKAGING 1 5.0

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 515

Page 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						·			
					,_				
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQA	: 5	Date: _(36/4/08		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NO		Corrective Action Section B			A			
DATE STE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
							:			
						,				
		t the second sec								

NOTE: Date & initial all entries

QA: N/C Closed: ____ Date: ____

Date:

Monday, 10/16/2006 2:01:26 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 29007

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W Da (1,68)

Dart Aerospace Ltd

	. oopao.									
W/O:			V	VORK ORDER CHANG	SES					
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					Ċ				ŭ	
Part No	•	PAR #	Fault Ca	tegory:						
		August 1			•	QA: N/C	Close	d:	_ Date: _	
NCR:		,	WORK OR	DER NON-CONFORM	ANCE (NCR)				
DATE	STEP	Description of N	c	Corrective Action Section B			Verification A		Approval	Approval
DATE		SIEP Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
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(3					4					
	*				191	-			i i i i i i i i i i i i i i i i i i i	
			,	*2						

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29007
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST									
	X First Article Prototype								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
0.600	+/-0.010	,595	/						
0.060	+/-0.005	,057	/						
Ø0.305	-0.002/+0.000	,304							
Ø0.191	+0.005/-0.000	,194	V						
Ø0.500	+/-0.010	,497	/						
0.030 x 20°	+/-0.010	, 030 × 20°	/						
R0.010	+0.010/-0.000	,010	/						
						·			
		100-							
									

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 06/11/03	Date: 06/11/03	Date:	17/H.

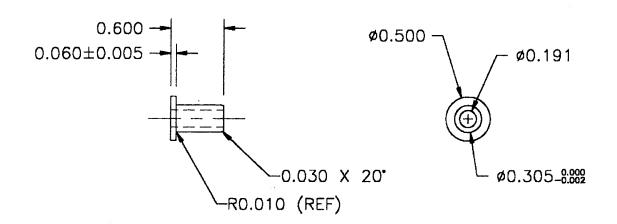
Rev	Date	Change	R	evised by	Approved
Α	03.12.12	New Issue		J/RF	14





***************************************	DESIGN	DRAWN BY	DART AEROSPACE L	
	CHECKED	APPROVED 0100	DRAWING NO. D2652	REV. A SHEET 1 OF 1
	DATE	TO' MY	TITLE	SCALE
	97:03:25		BUSHING	1:1





SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED